

Work Order ID 121572

Thursday, June 26, 2014 3:03:34 PM

121572

Page 1

Item ID: D3580-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Joggle Bracket

Stop

NS2

Start Date: 7/03/14

Start Qty: 44.00

44

Cust Item ID:

Required Date: 7/03/14

Req'd Qty: 44.00

44

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-06-26

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3580	Rev B
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100 DAS
23
14-10-2
100 FLOW WATER JET
Waterjet 00
Memo 37 0

FLOW CNC Waterjet DAS
23
14-10-2
304.050 1-Cut as per Dwg D3580
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

110 DAS
23
14-10-2
110 QC2- Inspect parts off machine FAI/FAIB 00
QC 37 0
Quality Control 00
Memo 89

120 DAS
38
9-89
14-10-2
120 QC8- Inspect parts - second check 00
QC 37
Quality Control 00
Memo 89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Work Order ID 121572

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Page 2

Item ID: D3580-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Joggle Bracket

Stop

NS2

Start Date: 7/03/14

Start Qty: 44.00

44

Cust Item ID:

Required Date: 7/03/14

Req'd Qty: 44.00

44

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

DAS
30
9-89

37

OCT 08 2014

Small Fab

Memo

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
38
9-89

37

14-10-8

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: 51050 0.00

Memo

0.00

DAS
28
9-89

37X

OCT 08 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
	Suspected Unapproved	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending		Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	<input type="checkbox"/>		
Centre Not Concentric		BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	<input type="checkbox"/>		
Cracks		Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	<input type="checkbox"/>		
Crimp/Kink/Ripple/Wave		Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	<input type="checkbox"/>		
Cuffs		Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	<input type="checkbox"/>		
Crushing		Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>				
Heat Treat		Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>				
Inspection Strip in Tube		Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>						
Marks/Chatter		Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>						
Turning Sequence		Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>						
Wave/Twist in Tube		Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>						

Work Order ID 121572

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121572

Page 3

Item ID: D3580-1 **Accept:** *N900040100* **Setup:** **Start:** *NS1*
Revision ID: **Stop:** *NS2*
Item Name: Joggle Bracket
Start Date: 7/03/14 **Start Qty:** 44.00 ***44*** **Cust Item ID:**
Required Date: 7/03/14 **Req'd Qty:** 44.00 ***44*** **Customer:**

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NB2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

Q.S. Number Stamp

44-10.9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced			
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up			
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure			
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld			
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
Crushing		Countersink		Misaligned/off center		Positioned Wrong					
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge		Other			
Inspection Strip in Tube		Drawing		Misread							
Marks/Chatter		Drill Holes		Off-set							
Turning Sequence		Finish		Out of Calibration							
Wave/Twist in Tube		Fit/Function		Out of Sequence							

Picklist Print

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Page 1

Work Order ID: 121572

121572
D3580-1

Parent Item: D3580-1

Parent Item Name: Joggle Bracket

Start Date: 7/03/14

Start Qty: 44.00

Required Date: 7/03/14

Required Qty: 44.00

Comments: IPP Rev :A New Issue 07.06.25 EC
 IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	658.3700	0.01	0.463157			DAS
M304S18GA 304/316 .050 Sheet									**	0.5		23 9-89	14-10-2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	646.37	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	38	
M126647	31.55	
M128254	91.57	
M128435	123.25	
M128864	65	
M129530	278	129530
MAT020	12	
124029	2	
M126098	10	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

 Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

 Skid-tube
 Crosstube
 Machining
 Small Fab
 Thermoforming
 Finishing
 Large Fab
 Composite
 Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier
 Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
			Bend		Folio/Program			Outside Dimensions		Pressure/Forced	
			BOM/Route		Grain			Over/Under tolerance		Set-up	
			Broken/Damage/Defect		Hardware			Part Incorrect		Temperature/Cure	
			Burrs		Inspection Incomplete/Unqualified			Part Lost/Missing		Weld	
			Contamination		Instructions Incomplete/Unclear			Part Moved		Wrong Stock Pulled	
			Countersink		Misaligned/off center			Positioned Wrong			
			Cut Too Short		Mislabeled			Power Loss/Surge		Other	
			Drawing		Misread						
			Drill Holes		Off-set						
			Finish		Out of Calibration						
			Fit/Function		Out of Sequence						

DART AEROSPACE LTD	Work Order:	<u>121572</u>
Description: Joggle Bracket	Part Number:	<u>D3580-1</u>
Inspection Dwg: D3580 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

-64-

29

DAS
38

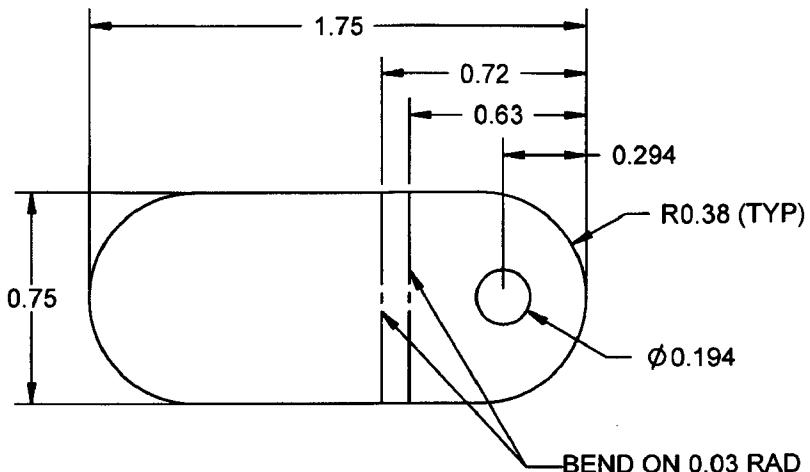
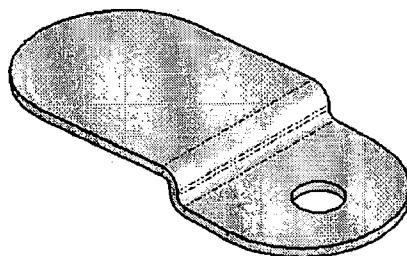
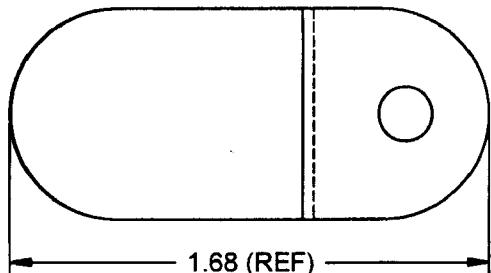
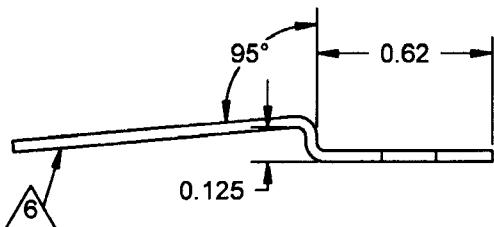
38

Measured by:	23 9.8g	Audited by:	9-89	Prototype Approval:	N/A
Date:	14-10-3	Date:	14-10-2	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>MM</i>	DRAWING NO. D3580
DATE 07.07.09		REV. B SHEET 1 OF 1 TITLE JOGGLE BRACKET SCALE 3:2

RELEASED07.07.09 *MM***D3580-1F FLAT PATTERN****D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121542
140630
MC3

SHOP COPY
RETURN TO
ENGINEERING